

Work Order ID 136950 -1

October 26, 2015 1:36:46 PM

136950

Page 1

Reprint
647.7501
B136950
REV. A

Item ID: 647.7501

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 9/21/2015 Start Qty: 1.00

Required Date: 9/25/2015 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

1

1

1
2

Approvals: Process Plan: *SLA* Date: *20151026*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7500	A								

SP

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

2X
DAS
27
9-89

OCT 27 2015

120 0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: *133436*
exp. date: *02/17*

PK

15/11/04

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89

NOV 24 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐		No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐		Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐		Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐		Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐		Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐		Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐		Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐		Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐		Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐		Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐		Manufacturing Process	☐	OTHER : _____						
Misidentified	☐		Past Due	☐							

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Item ID: 647.7501

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Lower Cutter Assembly

Stop ***NS2***

Start Date: 9/21/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/25/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00

RPP 136950

140

Packaging

Memo

0.00

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***DAG
6
9-29

NOV 24 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-11-25

MLJ 15-11-24

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 136950

136950

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 9/21/2015

Required Date: 9/25/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* Center Plate, Lower		Manufactured	No				Each	5.0000		1 2			BAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK114				5					
				113877				1					
				<u>119679</u>				4					
647.7810 *647 7810* Bracket A		Manufactured	No				Each	6.0000		1 2			BAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck015a				6					
				<u>136965</u>				6					
647.7811 *647 7811* Bracket B		Manufactured	No				Each	6.0000		1 2			BAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck015a				6					
				<u>136966</u>				6					
646.3015 *646 3015* Blade		Manufactured	No				Each	9.0000		2 4			BAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				stcck				9					
				<u>136216</u>				9					

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Work Order ID: 136950

136950

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 9/21/2015

Required Date: 9/25/2015

Start Qty: 1.00

Required Qty: 1.00

647.7601 Manufactured No

Each 4.0000

1 2

647 7601

Lower Deflector Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

cck065

4

137078

4

2 2

647.7815 Purchased No

Each 1.0000

1 2

647 7815

Fwd Bracket

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK114

1

113878

1

1 2

647.7814 Purchased No

Each 1.0000

1 2

647 7814

Fwd Bracket

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK114

1

113879

1

1 2

647.7816 Manufactured No

Each 0.0000

1 2

647 7816

Aft Bracket

B 138 240

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DAS
36
9-89

647.7817 Manufactured No

Each 0.0000

1 2

647 7817

Aft Bracket

B 138 364

15/11/23

DAS
36
9-89

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Work Order ID: 136950

136950

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 9/21/2015

Required Date: 9/25/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

2,232.000

26

52

NAS1149FN832P

Washer

BAS

27

9-89

Location

Loc Qty

Loc Code

GA

346

125268

346

ST260a

500

M133316

500

ST267

465

125268

100

M133284

365

st268

921

M130388

921

26 + 26

MS21042-3

MS21042L3

Purchased

No

Each

329.0000

3

6

MS21042-3

Nut / use MS21042L3

BAS

27

9-89

Location

Loc Qty

Loc Code

ST305

329

M128770

10

M129541

15

M129682

281

M130388

23

3 + 3

MS21042-08

MS21042L08

Purchased

No

Each

33.0000

13

26

MS21042-08

USE MS21042L08

BAS

27

9-89

Location

Loc Qty

Loc Code

ST304

25

122815

25

ST306

8

m130388

8

M132930

13 + 13

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Shop Packet Print

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Work Order ID: 136950

136950

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 9/21/2015

Required Date: 9/25/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

1,672.000

6 12

NAS1149F0332P

Washer

BAS

27

9-89

Location

Loc Qty

Loc Code

GA

162

122063

162

ST260a

1393

m128401

6

m131026

80

m131697

50

m133134

600

m133284

500

m133316

157

st268

117

123900

7

m130388

86

m133077

24

MS27039-08-19

Purchased

No

Each

486.0000

7 14

MS27039-08-19

Screw

BAS

27

9-89

Location

Loc Qty

Loc Code

cck007a

100

m133077

100

GA

186

m132930

186

ST273A

171

m131317

171

ST281

29

m131264

29

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Work Order ID: 136950

136950

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 9/21/2015

Required Date: 9/25/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-19

Purchased

No

Each

226.0000

3 6

MS27039-1-19

Screw

BAS

27

9-89

Location

Loc Qty

Loc Code

cck007a

200

m133134

200

GA

20

m124326

20

ST285

6

m127904

6

3+3

6 12

MS27039-08-24

Purchased

No

Each

397.0000

MS27039-08-24

Screw (MS27039-0824)

BAS

27

9-89

Location

Loc Qty

Loc Code

GA

291

124326

291

ST281

106

125654

106

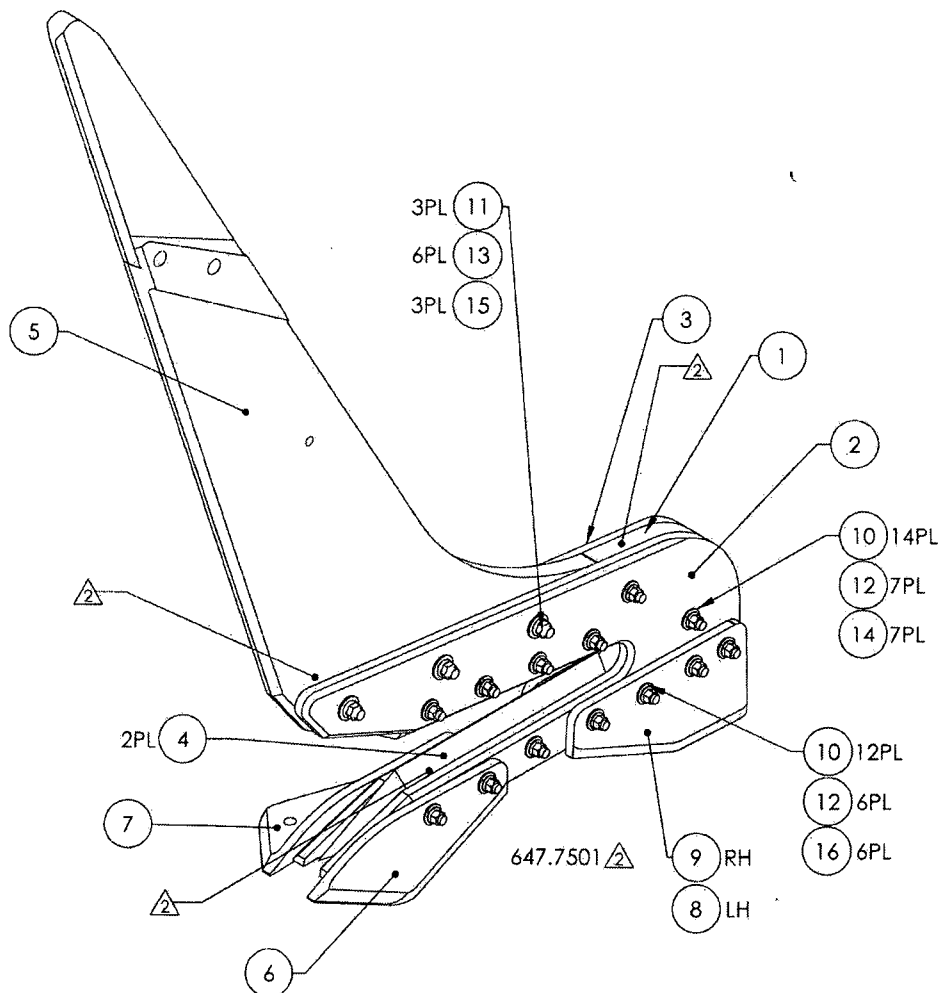
6+6

OCT 27 2015

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NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY



REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: FR2	11-21-09	H/C
2	INITIAL RELEASE	12-21-09	P. BRAVO
3	INCORPORATED ECH 02740	07-16-10	P. BRAVO

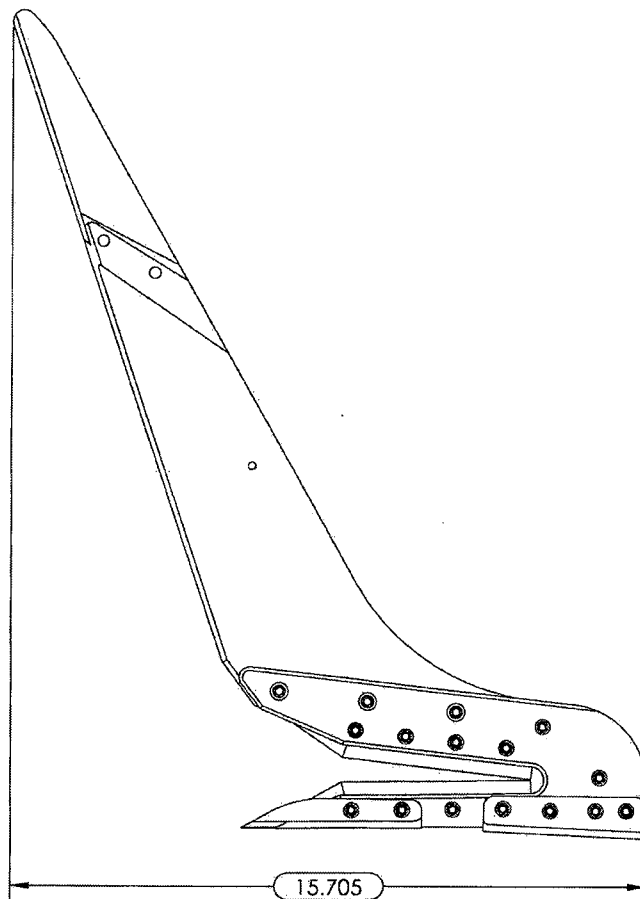
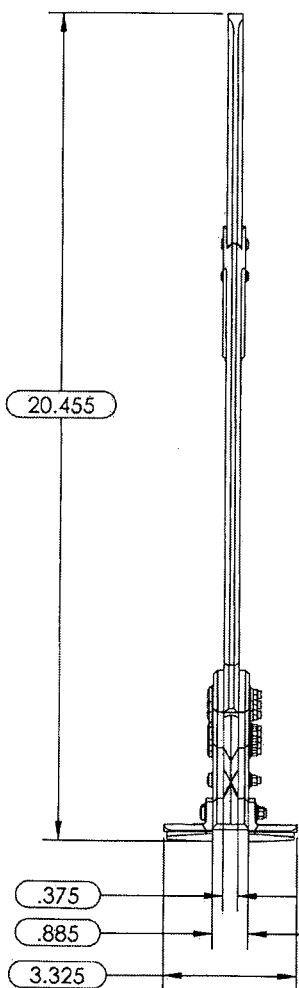
A/R	17	601.2045	RTV, LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
		647.7501	LOWER CUTTER ASSY		2
7501	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY	ORIGINAL DATE	APICAL INDUSTRIES
NEXT ASSY (S)	11-21-09	2608 TEMPLE HEIGHTS DR.
647.7300	DRAWN BY: A. DIAZ	OCEANSIDE, CA. 92056-3512 (760)724-5300
	CHECKER: P. BRAVO	
	DRAWING APPROVAL: P. BRAVO	
	CONTRACT NO.	
	UNLESS OTHERWISE SPECIFIED	
	DIMENSIONS ARE IN INCHES	
	TOLERANCES ARE:	
	7 PLACE DECIMALS ±.010	
	3 PLACE DECIMALS ±.010	
	ANGLES ±.5°	
	SIZE: 1/8" X 1/2" X 1/4"	DWG. NO. 647.7500
	SCALE: NONE	REV. A
		SHEET 1 OF 2

20151025

54136950

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ORIGINAL DATE 11-24-07		APICAL INDUSTRIES	
DRAWN BY A. GUAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		LOWER CUTTER ASSY	
DRAWING APPROVAL P. BRAVO		SIZE B	
CONTRACT NO.		CAGE CODE 07M26	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.010 ANGLES ±.2°		DWG. NO. 647.7500	
SCALE NONE		REV. A	
SHEET		2 OF 2	